

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027170**Date Inspected:** 11-Feb-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

13E PP121.5 E4 Lifting Lug Holes #1-4 (Exterior)

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of the welds at the locations listed above. These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1. 5-2002, section 6, table 6.3. This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications. These joints are designated as Seismic Performance Critical members (SPCM).

13E PP118.5 E4 Lifting Lug Hole #4 (Exterior)

This QA Inspector observed QC Inspector Fred Von Hoff utilize a Bridge Cam Gage to measure the fit-up of the 20 mm plate in the B-U4a joint on lifting lug hole #4 at 13E PP118.5 E4. This QA Inspector verified the fit-up as acceptable and employed a 66°C Tempilstik to ensure the minimum pre-heat temperature had been achieved. This QA Inspector randomly observed ABF welder Salvador Sandoval (ID 2202) performing the Shielded Metal Arc Welding (SMAW) process in the (1G) flat position and observed the QC Inspector verify the welding parameters were in accordance with the above mentioned WPS. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress and appeared to be in general

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compliance with the approved WPS and the contract specifications.

Note: The QAI reviewed the observations and inspection with QA Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QAI and the QA Lead Inspector concurs with the QA report.

Summary of Conversations:

The were no pertinent conversations to report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
